

# Work Order ID 84930

**\*84930\***

Page 1

May-29-12 2:56:57 PM

Item ID: D209-669-043

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/29

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 003 per ELN 12-SEP

N/A

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

SAD 12-06-20

SAD 12-06-21

7/6-12-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84930

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May-29-12 2:56:57 PM

Item ID: D209-669-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC3- Inspect Part Finish

0.00

\*120\*

QC Memo

0.00

Quality Control

① SAG 12-07-04

130 Skidtubes

0.00

\*130\*

Skidtubes Memo

0.00

Skidtubes -Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting  
Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 B121409

Sikaflex expire date: 13-04-12

Start Time: 10h00 Date: 12-07-04

Fin Time: 9h30 Date: 12-07-04

pick:

Qty P/N description

1 D2926-3

Web

B/N

B86416

① SAG 12-07-04

W/O: 84930		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 209-669-043 PAR #: \_\_\_\_\_ Fault Category: Landing Gear NCR: Yes ☒ No ☐ DQA: 2/27 Date: 12/6/27  
 Resolution: Acceptable Disposition: Acceptable QA: N/C Closed: 2/27 Date: 12/7/27

NCR: 12-1627		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/4	130	I-beam is misaligned. ≈ 1/8" too far aft. Xbolt spacers can't install.	GP 12/7/5	Acceptable to ovalize I-beam holes to allow installation of Xbolt spacers	8F 12/7/05	12-7-5	GP 12/7/5	S. 12/7/05
		R.C. employee didn't align it correctly						

NOTE: Date & initial all entries

# Work Order ID 84930

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Item ID: D209-669-043

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**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
<b>*140*</b>	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
<b>*150*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160		0.00							
<b>*160*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

>

DL 12/27/05

PTC

CF 12.789

1 0 BE 267/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D209-669-043

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00

**\*170\***

Large Fab

Skidtubes

Memo

0.00

Skidtubes

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Debur

① SAG 12-07-09

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

Silvator

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



# Work Order ID 84930

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Item ID: D209-669-043 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Replacement Skidtube  
 Start Date: 29/05/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 16/07/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
*200*									
HandFinish	Memo	0.00				1	MB	12-7-10	
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*210*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9-40								
	OVEN TEMPERATURE: 3200 F								
	FINISH TIME: 10-10								
220	QC3- Inspect Part Finish	0.00							
*220*									
QC	Memo	0.00							
Quality Control									

M 12/841

IX / M-L 12/07/10

1 / (SP) 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

May-29-12 2:56:57 PM

**Item ID:** D209-669-043

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Replacement Skidtube

Stop \*NS2\*

**Start Date:** 29/05/2012    **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date:** 16/07/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

**Tool ID****Tool #**Plan  
Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

230

0.00

\*230\*

## HandFinishing

0.00

HandFinish

## Memo

## Hand Finishing

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R	Sikaflex-291	21130
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Sikaflex expire date: 14/03

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 121130

Sikaflex expire date: 14/03

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: 22320

1 ~~2~~ SP 12/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 84930

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Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240 QC5- Inspect part completeness to step on W/O

0.00

*Salv*

**\*240\***

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

0.00

**\*250\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev:

*ADD 84914*

260

0.00

**\*260\***

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

*MLJ 12/07/23*

*MLJ 12/07/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Page 1

Work Order ID: 84930

**\*84930\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 <b>*D4202-1*</b> Spacer		Manufactured	No				Each	81.0000		19			
				B83263					**	19		CF 12-7-5	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG			5						
				77727			5						
				LG002			76						
				78806			6						
				79810			70						
D2500-1-190 <b>*D2500-1-190*</b> Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**			SAD 12-06-19	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				HALL			91						
				74777			14						
				80061			77						
D2926-3 <b>*D2926-3*</b> Web		Manufactured	No			110	Each	0.0000	1	1			
								B86446	**			SAD 12-07-04	
D2855 <b>*D2855*</b> Cap		Manufactured	No			230	Each	21.0000	2	2			
									**	2		(20) 12/07/11	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FP002	84952		21						
				65519			2						
				73347			16						
				75074			3						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 84930

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

\*84930\*

\*D209-669-043\*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

230

Each

1,090.000

4

4

\*AN3-5A\*

Bolt

\*\*

4

28

12/07/10

## Location

## Loc Qty

## Loc Code

ST350

1090

115371

46

117423

124

118626

31

119355

200

120187✓

500

121185

189

AN960JD10L

✓ NAS1149D0332J ✓

Purchased

No

230

Each

0.0000

4

4

\*AN960JD10L\*

Washer

121011✓

\*\*

4

28

12/07/10

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

\*ALS7-1032-130\*

Insert

\*\*

44

28

12/07/10

## Location

## Loc Qty

## Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444✓

2000

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*84930\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**\*AN3C4A\***

BOLT

\*\*

44

(2P)

12/07/10

Location

Loc Qty

Loc Code

ST350

122151✓

1458

120187

57

120521

28

120769

38

121205

1000

121556

335

AN960C10L

✗ NAS1149C0332  
R

Purchased

No

230

Each

0.0000

44

44

**\*AN960C10I \***

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**\*D2594-3\***

O-Ring, 205 Skidtube

\*\*

44

(2P)

12/07/10

122063✓

\*\*

14

(2P)

12/07/10

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755✓

1343

May-29-12 2:57:01 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

\*84930\*

\*D209-669-043\*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

\*D2594-1\*

Plug, 205 Skidtube

\*\*

14

SP

12/07/10

Location

Loc Qty

Loc Code

FP001

84951 ✓

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

D3564-9

Manufactured No

230

Each

22.0000

1

1

\*D3564-9\*

Wearshoe

\*\*

1

SP

12/07/10

Location

Loc Qty

Loc Code

FG

84870 ✓

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11

Manufactured No

230

Each

8.0000

1

1

\*D3564-11\*

Wearshoe

\*\*

1

SP

12/07/10

Location

Loc Qty

Loc Code

FG

83910 ✓

4

77056

4

FP001

4

80341

4

May-29-12 2:57:01 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 2:57:01 PM

Page 5

Work Order ID: 84930

\*84930\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

\*D3564-5\*

Wearshoe

\*\*

1

SP

12/07/10

Location

Loc Qty

Loc Code

FG

84869 ✓

2

34806

2

FP001

11

77609

3

82254

8

D3566-1

Manufactured No

230

Each

31.0000

2

2

\*D3566-1\*

Gasket

\*\*

2

SP

12/07/10

Location

Loc Qty

Loc Code

FP

84879 ✓

-22

81619

10

FP002

53

68924

2

80919

3

83898

16

D3566-5

Manufactured No

230

Each

21.0000

1

1

\*D3566-5\*

Gasket

\*\*

1

SP

12/07/10

Location

Loc Qty

Loc Code

FP

84881 ✓

12

82275

12

FP002

9

80374

3

82274

6

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Page 5

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



B

B

B

B

QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

## GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER  
NO. 84930 MCT  
12/05/25

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07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D2906	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

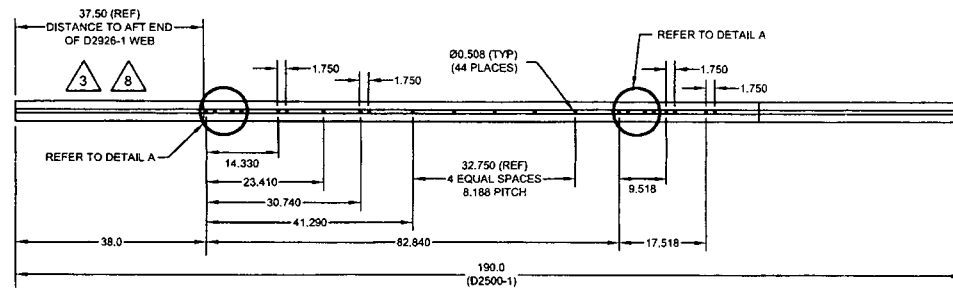
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

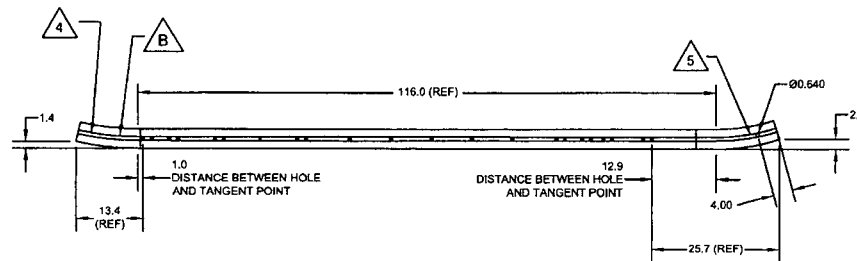
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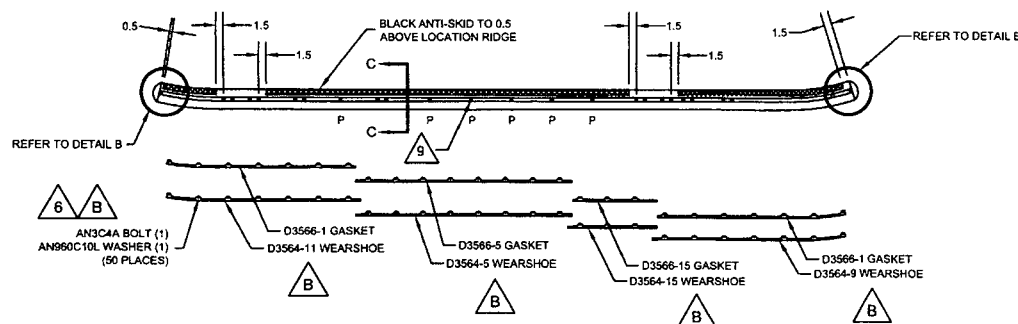
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**D2906-1 DRILLING DETAIL**

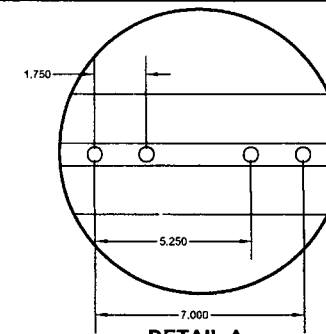


**D2906-041 BENDING AND CUTTING DETAIL**

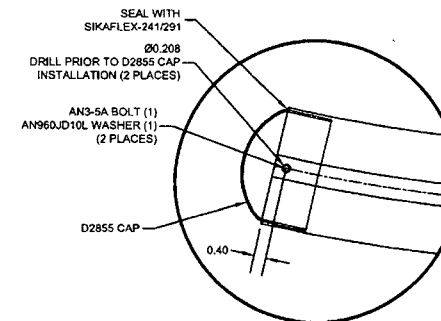


**D2906-041 ASSEMBLY DETAIL**

84930



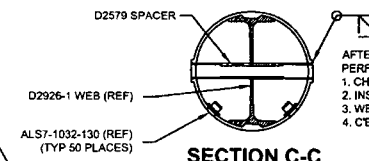
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

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**SECTION C-C**  
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

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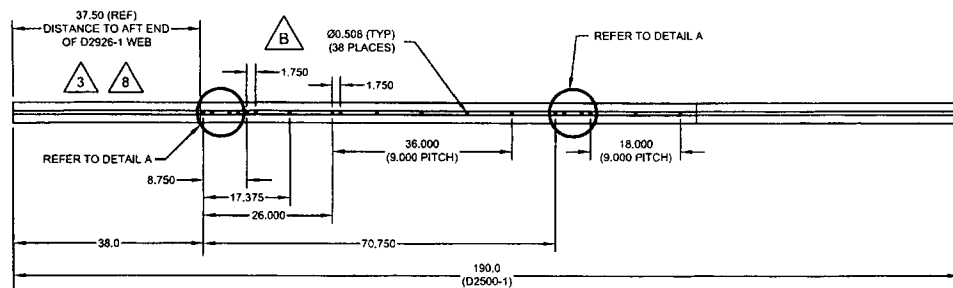
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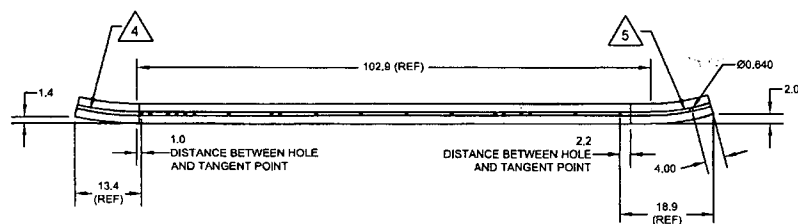
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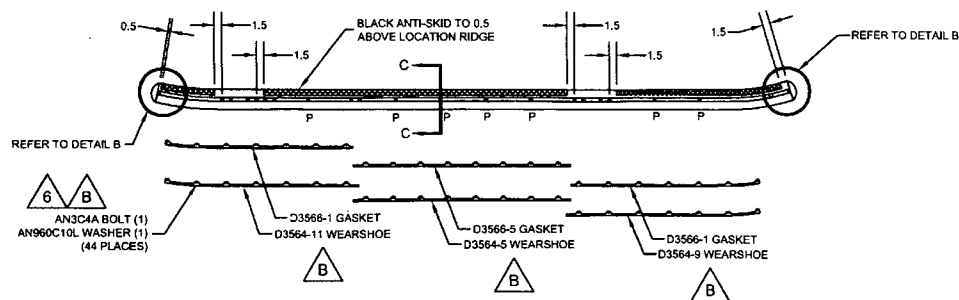
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**D2906-3 DRILLING DETAIL**

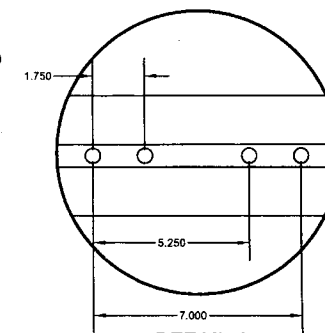


**D2906-043 BENDING AND CUTTING DETAIL**

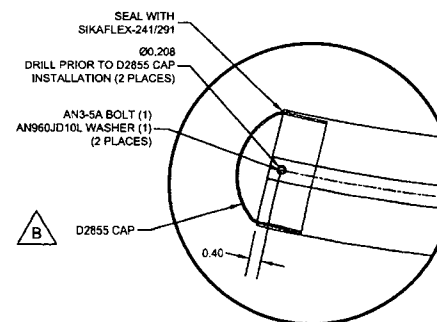


**D2906-043 ASSEMBLY DETAIL**

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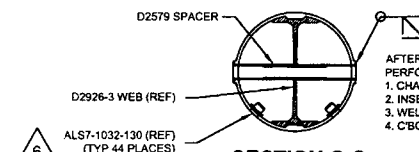
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

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**SECTION C-C**  
SCALE 1:4

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